

Work Order ID 88957

Saturday, August 11, 2012 12:51:07 PM

88957

Page 1

Item ID: D412-709-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Hinge Panel Door Modification

Stop

NS2

Start Date: 8/13/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/08/13 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev A

100 *100* DOCUMENT CONTROL 0.00 DAS 16 9-83 12/08/13 JB

DC Document Control

Memo Photocopy D412-709 bluefile & type labels per PPP D412-709-015 CHG002

MLJ 12-9-12

(4)

JB

105 *105* Pick Kit 0.00 DAS 16 9-83 12/09/11 JB

Packaging

Memo

Packaging

110 *110* QC4- 100% Inspect kits for completeness 0.00 DAS 16 9-83 12/08/13 JB

QC Quality Control

Memo

(X4) 12/09/11 JB

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>						
	Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>							
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>							
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>								
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>								

Work Order ID 88957

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Page 2

Item ID: D412-709-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Hinge Panel Door Modification

Stop

NS2

Start Date: 8/13/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Packaging

Packaging

0.00

12/9/13 (4)

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-709-015

Location: _____

PPP Rev: _____

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/9/14 (4)

MF
12-09-13

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
			Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data <input type="checkbox"/>	Equip/Tooling <input type="checkbox"/>										
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear			General								
Bending <input type="checkbox"/>			Bend <input type="checkbox"/>			Grain <input type="checkbox"/>		Ovalized <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/>	
Centre Not Concentric to O/S <input type="checkbox"/>			BOM/Route <input type="checkbox"/>			Hardware <input type="checkbox"/>		Over/Under tolerance <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>	
Cracks <input type="checkbox"/>			Broken/Damaged <input type="checkbox"/>			Inspection Incomplete <input type="checkbox"/>		Part Incorrect <input type="checkbox"/>		Weld <input type="checkbox"/>	
Crushed/Crimped. <input type="checkbox"/>			Burrs <input type="checkbox"/>			Instructions Incomplete/Unclear <input type="checkbox"/>		Part Lost/Missing <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>	
Cuffs <input type="checkbox"/>			Contamination <input type="checkbox"/>			Maintenance <input type="checkbox"/>		Part Moved <input type="checkbox"/>			
Heat Treat <input type="checkbox"/>			Countersink <input type="checkbox"/>			Mislabeled <input type="checkbox"/>		Positioned Wrong <input type="checkbox"/>			
Inspection Strip in Tube <input type="checkbox"/>			Cut Too Short <input type="checkbox"/>			Misread <input type="checkbox"/>		Power Loss/Surge <input type="checkbox"/>			
Ripples in Bend <input type="checkbox"/>			Drill Holes <input type="checkbox"/>			Offset <input type="checkbox"/>				Other <input type="checkbox"/>	
Torque Waves in Extrusion <input type="checkbox"/>			Drawing <input type="checkbox"/>			Out of Calibration <input type="checkbox"/>					
Turning Sequence <input type="checkbox"/>			Finish <input type="checkbox"/>			Out of Sequence <input type="checkbox"/>					
Wave/Twist in Tube <input type="checkbox"/>			Folio <input type="checkbox"/>			Outside Dimensions <input type="checkbox"/>					

Picklist Print

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Page 1

Work Order ID: 88957

Parent Item: D412-709-015

Parent Item Name: Hinge Panel Door Modification

Start Date: 8/13/2012

Required Date: 8/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev. B 05.03.08 D3240-1 no longer made in house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2126 Seal <i>Cut each seal 72.00" long</i>	Manufactured	No			110	f	212.2603		6	25.263158		<i>JB</i>	
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Location	Loc Qty	Loc Code
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ST405	212.26029	
57106	4	
68336	2.44679	
76094	205.8135	

D3236-1 Window	Manufactured	No			110	Each	4.0000		U	4	<i>JB</i>	<i>10</i>
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Location	Loc Qty	Loc Code
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ST217	4	
72947	1	
79808	3	

D3240-1 Frame	Manufactured	No			110	Each	10.0000		1	72947	<i>JB</i>	<i>SD</i>
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Location	Loc Qty	Loc Code
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ST215	6	
86780	6	

ST217	4	
73223	4	

Location	Loc Qty	Loc Code
----------	---------	----------

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-709

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
			1	X			D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
						1	X	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
							D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041	WINDOW ASSEMBLY
		1					D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
					1		D3237-1-0720	SEAL RETAINER
				1			D3237-1-0980	SEAL RETAINER
					1		D3237-3-0720	SEAL FILLER
				1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
						1	D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1				1	1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C
Date: 06.11.27